

Work Order ID 55712

January 28, 2010 11:02:47 AM



Page 1

Item ID: D3954-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Chain Lug

Start Date: 1/29/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 2/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-1-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3954

RevB

100

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

mill to size

RB 10-1-28

⑦

110

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3954

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

RB 10-1-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

January 28, 2010 11:02:47 AM



Accept

**Setup Start**

Stop



Start Date: 1/29/2010 **Start Qty:** 6.00

**Cust Item ID:**

Required Date: 2/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00



QC

Memo

0.00

Quality Control

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

Mill as per Dwg

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

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Cust Item ID:

Required Date: 2/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Identify as per dwg & Stock Location: CAL

0.00



Packaging

Memo

0.00

Packaging

Prop *Q*

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/11
MF
10-2-09

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Picklist Print

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Page 1

Work Order ID: 55712

Parent Item: D3954-5

Parent Item Name: Chain Lug


Comments:

Start Date: 1/29/2010

Required Date: 2/15/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010B1.000X02.000		Purchased	No			100	f	9.0600	3.1579			
												
1010-1025 Steel Bar 1.00 x 2.00												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

9.06

107436

9.06

110368

110368

HB 10-1-28

①

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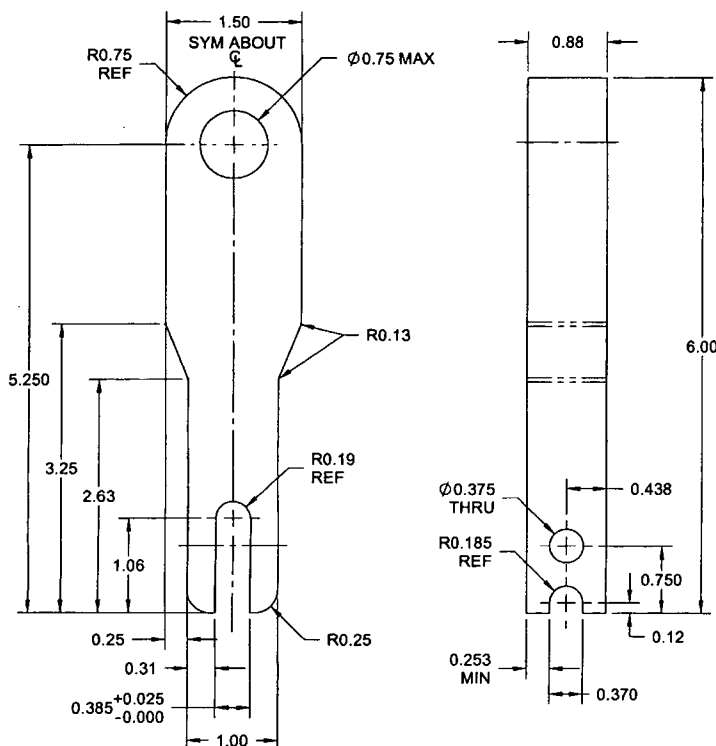
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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D3954-5 CHAIN LUG

NOTES:

1) MATERIAL: -5/-7: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B

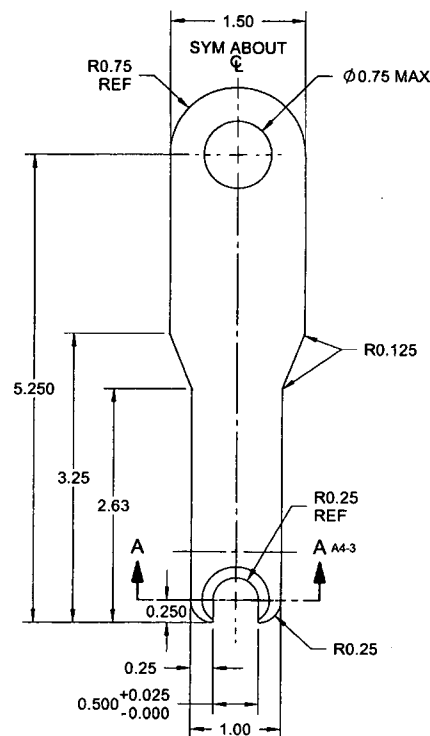
9: AISI 1010-1025 MILD STEEL ROUND BAR
PER DART SPEC M1018-R

ALTERNATE MATERIAL:

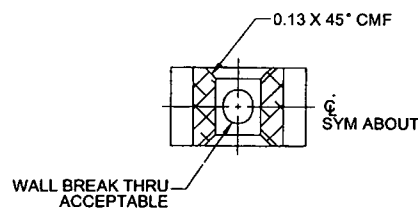
-5/-7: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

-9: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

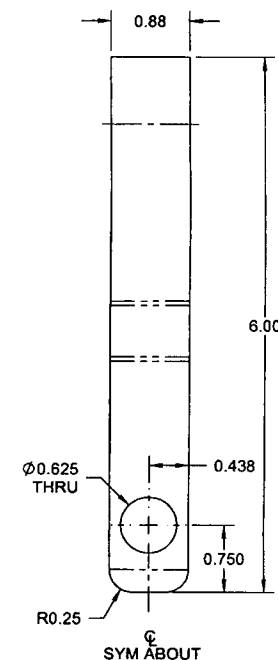
- 2) FINISH -7 ONLY: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2 **B**
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT -5/-7: 1.56 lbs EACH
 -9: 0.05 lbs



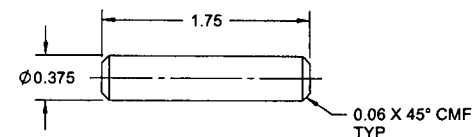
D3954-7 RATCHET LUG




SECTION A-A C3-3



D3954-9 GWT CHAIN PIN



DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3954	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		N/A	MISC MACHINED PARTS GWT KIT
DATE	09.10.15	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

#55712

RELEASED
2009-10-19

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